

Work Order ID 95540

95540

*January-11-13 8:36:42 AM

Page 1

Item ID: D3889-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Panel, Floor

Stop

NS2

Start Date: 1/11/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-01-11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3889	A	
-------	---	--

100 0.00

100

Waterjet

Memo

0.00

(4)

B3-(-)7

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

(4)

B3-(-)7

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: .

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending	Bend	Grain	Ovalized	Pressure/Forced			
				Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure			
				Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld			
				Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled			
				Cuffs	Contamination	Maintenance	Part Moved				
				Heat Treat	Countersink	Mislabeled	Positioned Wrong				
				Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge				
				Ripples in Bend	Drill Holes	Offset					
				Torque Waves in Extrusion	Drawing	Out of Calibration					
				Turning Sequence	Finish	Out of Sequence					
				Wave/Twist in Tube	Folio	Outside Dimensions					

Work Order ID 95540

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Page 2

Item ID: D3889-041

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Panel, Floor

Stop

NS2

Start Date: 1/11/13 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 1/25/13 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

15
DAS

131.28

4

120

QC

Memo

0.00 131.28

Quality Control

130

130

Small Fab

Small Fab

Memo

0.00

u/a

140

Pick Kit

0.00

140

Packaging

Packaging

Memo

0.00

4

F
13-02-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order ID 95540

January-11-13 8:36:42 AM

95540

Page 3

Item ID: D3889-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Panel, Floor

Stop

NS2

Start Date: 1/11/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Small Fab	Memo	0.00					4		FF 13-02-12
Small Fab	1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: M124297								
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	Shb	132, D		4			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00	ST 201A	JL PPL 95531					R-13/2/12 (4)

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			<input type="checkbox"/> Rework	<input type="checkbox"/> Skid-tube	<input type="checkbox"/> Crosstube	<input type="checkbox"/> Water Jet	<input type="checkbox"/> Engineering			
			<input type="checkbox"/> Scrap	<input type="checkbox"/> Machining	<input type="checkbox"/> Small Fab	<input type="checkbox"/> Prod. Eng. Coor.	<input type="checkbox"/> Quality			
			<input type="checkbox"/> Use-as-is	<input type="checkbox"/> Thermoforming	<input type="checkbox"/> Finishing	<input type="checkbox"/> Rec/Store/Packaging	<input type="checkbox"/> Other			
			<input type="checkbox"/> Work Order Update	<input type="checkbox"/> Large Fab	<input type="checkbox"/> Composite	<input type="checkbox"/> Supplier				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
				<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced		
<input type="checkbox"/> Centre Not Concentric to O/S				<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure			
<input type="checkbox"/> Cracks				<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspector Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld			
<input type="checkbox"/> Crushed/Crimped.				<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled			
<input type="checkbox"/> Cuffs				<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved				
<input type="checkbox"/> Heat Treat				<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong				
<input type="checkbox"/> Inspection Strip in Tube				<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge				
<input type="checkbox"/> Ripples in Bend				<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset					
<input type="checkbox"/> Torque Waves in Extrusion				<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration					
<input type="checkbox"/> Turning Sequence				<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence					
<input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions					

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending				Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
Centre Not Concentric to O/S				BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
Cracks				Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>				
Crushed/Crimped.				Burrs <input type="checkbox"/>	Instruction is Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
Cuffs				Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>					
Heat Treat				Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
Inspection Strip in Tube				Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>					
Ripples in Bend				Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>					
Torque Waves in Extrusion				Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
Turning Sequence				Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						
Wave/Twist in Tube				Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>						

Picklist Print

January-11-13 8:36:46 AM

Page 1

Work Order ID: 95540

95540

Parent Item: D3889-041

D3889-041

Parent Item Name: Panel, Floor

Start Date: 1/11/13

Required Date: 1/25/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	335.0613	8.1925	34.49474	**	B13-1-27	

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
MAT019	335.0613	
121803	335.0613	

D3889-3 Manufactured No

D3889-3

Gasket

95541

140 Each 0.0000

1 4

**

4

FF 13-02-12

(8)

121803

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
	Centre Not Concentric to O/S <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
	Cracks <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
	Crushed/Crimped. <input type="checkbox"/>	Instruction Is Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
	Cuffs <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
	Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
	Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
	Ripples in Bend <input type="checkbox"/>	Offset <input type="checkbox"/>									
	Torque Waves in Extrusion <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
	Turning Sequence <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
	Wave/Twist in Tube <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

DART AEROSPACE LTD	Work Order:	95540
Description: Panel	Part Number:	D3889-1
Inspection Dwg: D3889	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

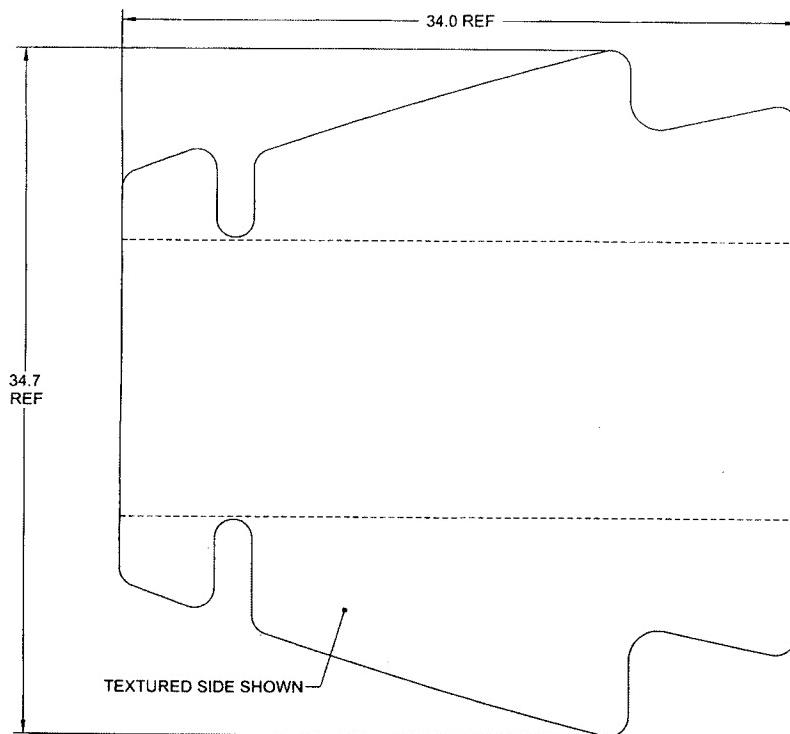
— 9 —

Measured by: B	Audited by: 15 S.C.	Prototype Approval: N/A
Date: 13-1-25	Date: 13-1-25	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3889-041	KJ	[Signature]

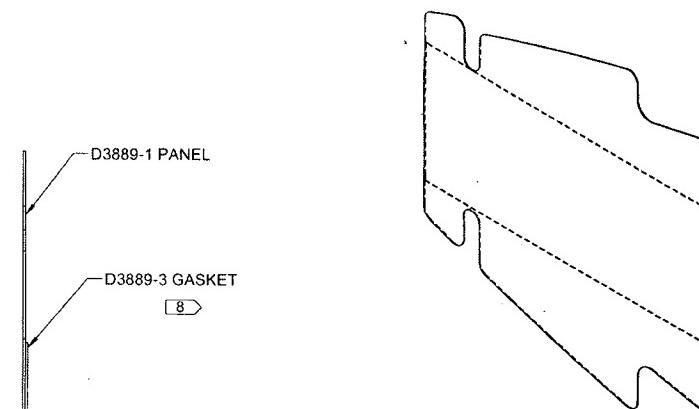
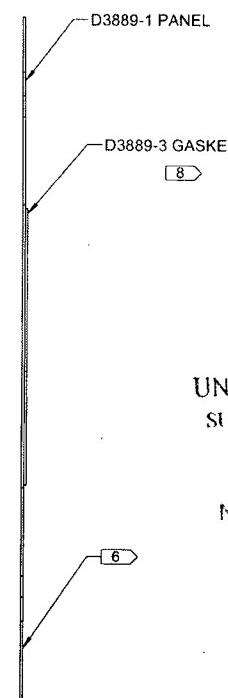
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

D3889-041 PANEL, FLOOR

NOTES:

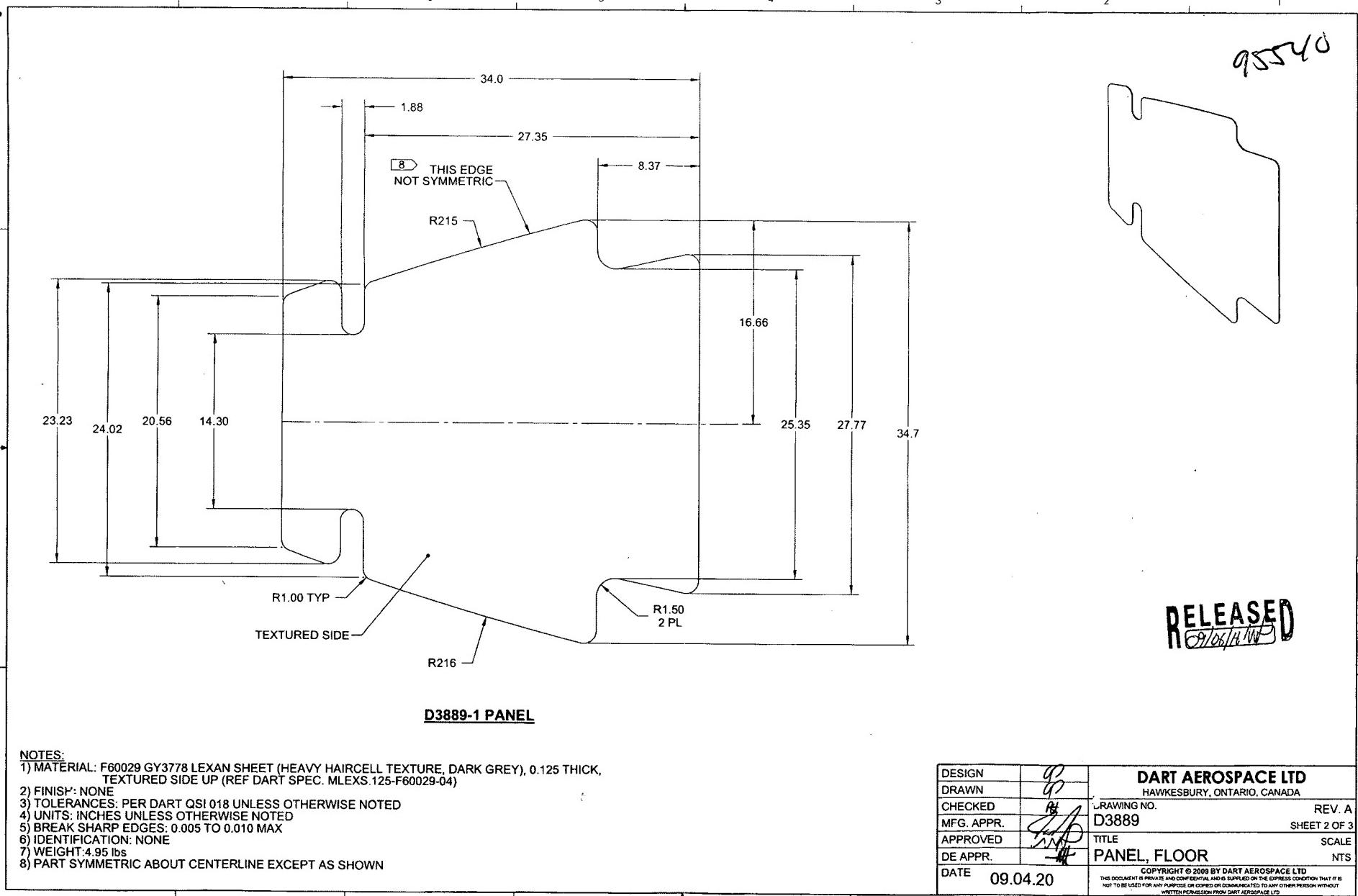
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



RELEASER
R.
UNCONTR.
SUBJECT
WITNESS
WITNESS
NO. 95540 ML5
13-01-11

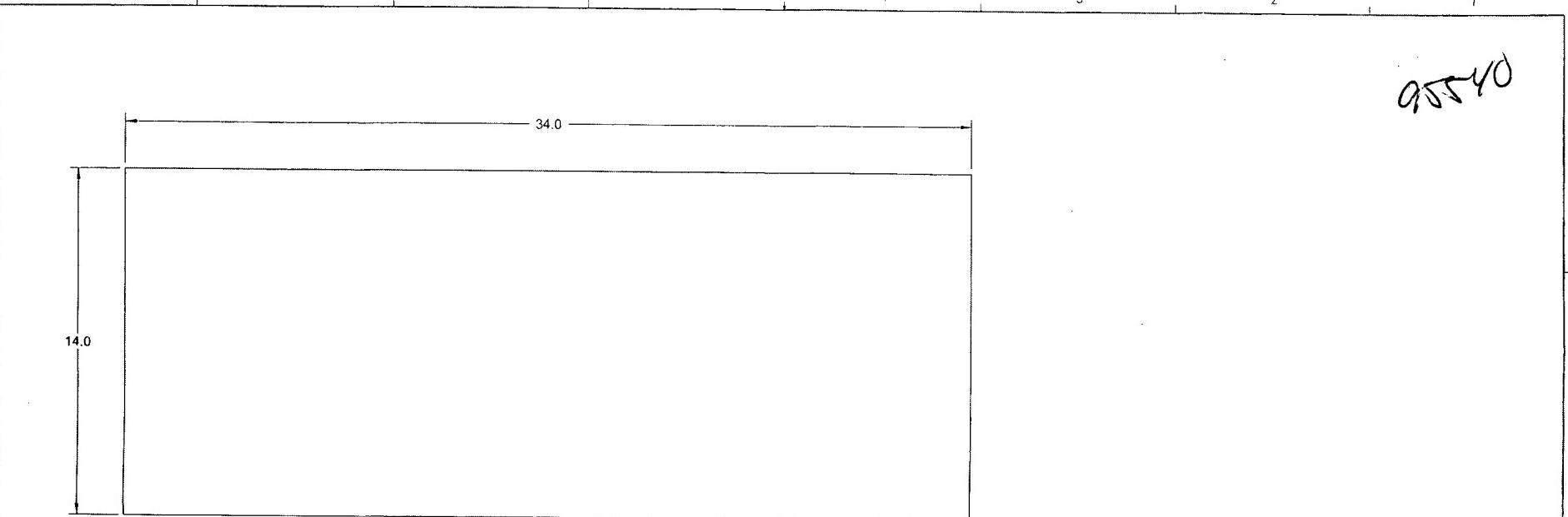
RELEASED
R. 9/16/20

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>B</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>M</i>	DRAWING NO.	R.EV. A
MFG. APPR.	<i>M</i>	D3889	SHEET 1 OF 3
APPROVED	<i>M</i>	TITLE	SCALE
DE APPR.	<i>M</i>	PANEL, FLOOR	NTS
DATE	09.04.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	<i>9</i>	DART AEROSPACE LTD	
DRAWN	<i>9</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A</i>	DRAWING NO.	
MFG. APPR.	<i>S</i>	REV. A	
APPROVED	<i>S</i>	D3889	
DE APPR.	<i>S</i>	SHEET 2 OF 3	
TITLE		SCALE	NTS
PANEL, FLOOR			
DATE 09.04.20			

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D3889-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	<i>99</i>	DART AEROSPACE LTD	
DRAWN	<i>PP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JW</i>	D3889	SHEET 3 OF 3
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>JW</i>	PANEL, FLOOR	NTS
DATE	09.04.20	COPRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
09/06/16 JW